

**Work Order ID 111760**

January-21-14 11:26:35 AM

**\*111760\***

Page 1

Item ID: D2432

Revision ID:

Item Name: Bearpaw 19" X 24"

Start Date: 1/21/14 Start Qty: 16.00

Required Date: 2/04/14 Req'd Qty: 16.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 1-21-14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2432

H

120

**\*120\***

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

Cut Blank as per D2432 File

0.00

0.00

16 0 Jm 14-02-15

130

**\*130\***

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio and Dwg D2432 Identify as D2432F  
3-Deburr

0.00

0.00

16 0 M 14/03/06

140

**\*140\***

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

16 0 M 14/03/06

Work Order ID 111760

\*111760\*

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January-21-14 11:26:35 AM

Item ID: D2432 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bearpaw 19" X 24"  
 Start Date: 1/21/14 Start Qty: 16.00 \*16\* Cust Item ID:  
 Required Date: 2/04/14 Req'd Qty: 16.00 \*16\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
*150*						16			SL143-11
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: _____	0.00							
*160*						14	14/3/12		CL
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
*170*									
QC	Memo	0.00							
Quality Control									

ML5 14-03-12  
 14-03-12

# Picklist Print

January-21-14 11:26:39 AM

Page 1

Work Order ID: 111760

\*111760\*

Parent Item: D2432

\*D2432\*

Parent Item Name: Bearpaw 19" X 24"

Start Date: 1/21/14

Required Date: 2/04/14

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

534.7082

3.7

60

\*MUHMWB10\*

\*\*

Jm14-02-15

UHMW 1" Black - 48"x120"

Tivar Mfg.#52480104

Location

Loc Qty

Loc Code

MAT018

534.7082

121278

9.6282

122575

47.6

123229

53

123949

6.96

124758

17.52

m127891

400

128011

128011

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	111 760
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2432
<b>Inspection Dwg:</b> D2432 <b>Rev:</b> H		<b>Page 1 of 1</b>	

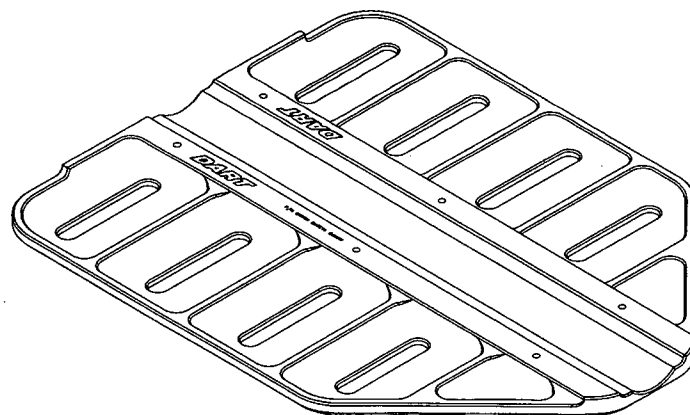
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		MH-04	Caliper
5.500	+/-0.030	5.504	✓			
0.200	+/-0.030	1.985	✓			
0.25 x 45°	+/-0.030	0.245 x 45°	✓			
R0.250	+/-0.030	0.255	✓		and gauge	—
0.250	+/-0.010	0.260	✓		MH-04	Caliper
0.625	+/-0.030	0.640	✓			
0.375	+/-0.010	0.380	✓			
0.950	+0.030/0.010	0.950	✓			
19.000	+/-0.030	19.000	✓		MH-07	Tape
3.14	+/-0.030	3.130	✓		MH-04	Caliper
3.28	+/-0.030	3.308	✓			
Ø0.260	+0.005/-0.000	0.260	✓			
Ø0.93	+/-0.030	0.928	✓			
0.30	+0.030/-0.000	0.310	✓			
23.750	+/-0.030	23.75	✓		Tape	MH-07
4.250	+/-0.010	4.295	✓		MH-04	Caliper
2.000	+/-0.030	2.020	✓			
9.000	+/-0.010	9.00	✓		CNC-02	Caliper
9.000	+/-0.010	9.00	✓		CNC-02	Caliper
Ø0.35, 350	+/-0.010	0.405	✓		MH-04	Caliper

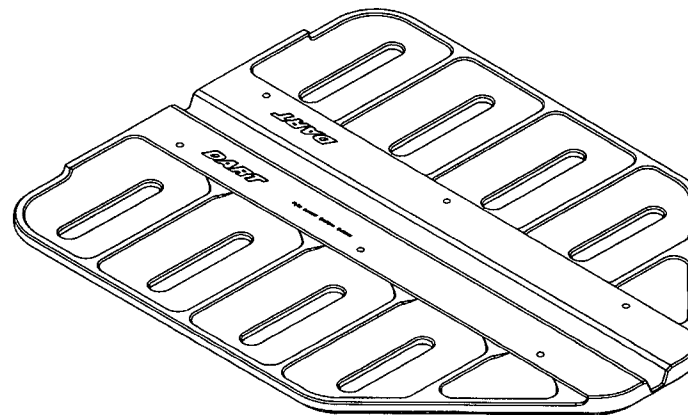
<b>Measured by:</b> MM	<b>Audited by:</b> JK	<b>Preliminary Approval:</b>
<b>Date:</b> 14/03/06	<b>Date:</b> 14-3-11	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	MM

111760  
ML9  
14-01-21



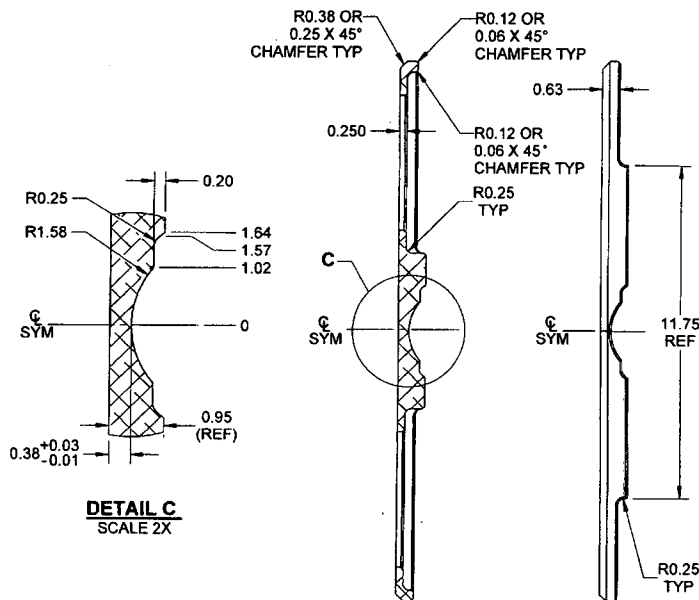
**D2432F BEARPAW**



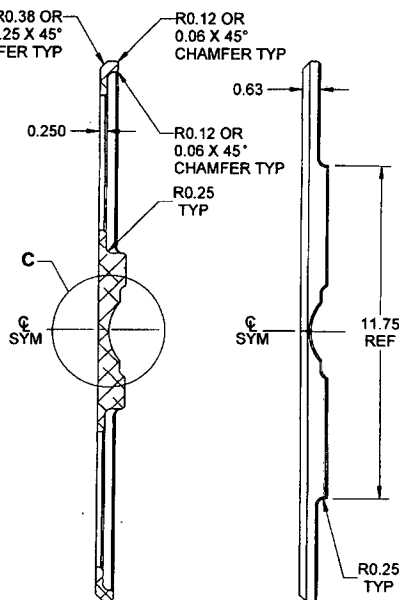
**D2432-3 BEARPAW**

**RELEASED**  
2012-10-16

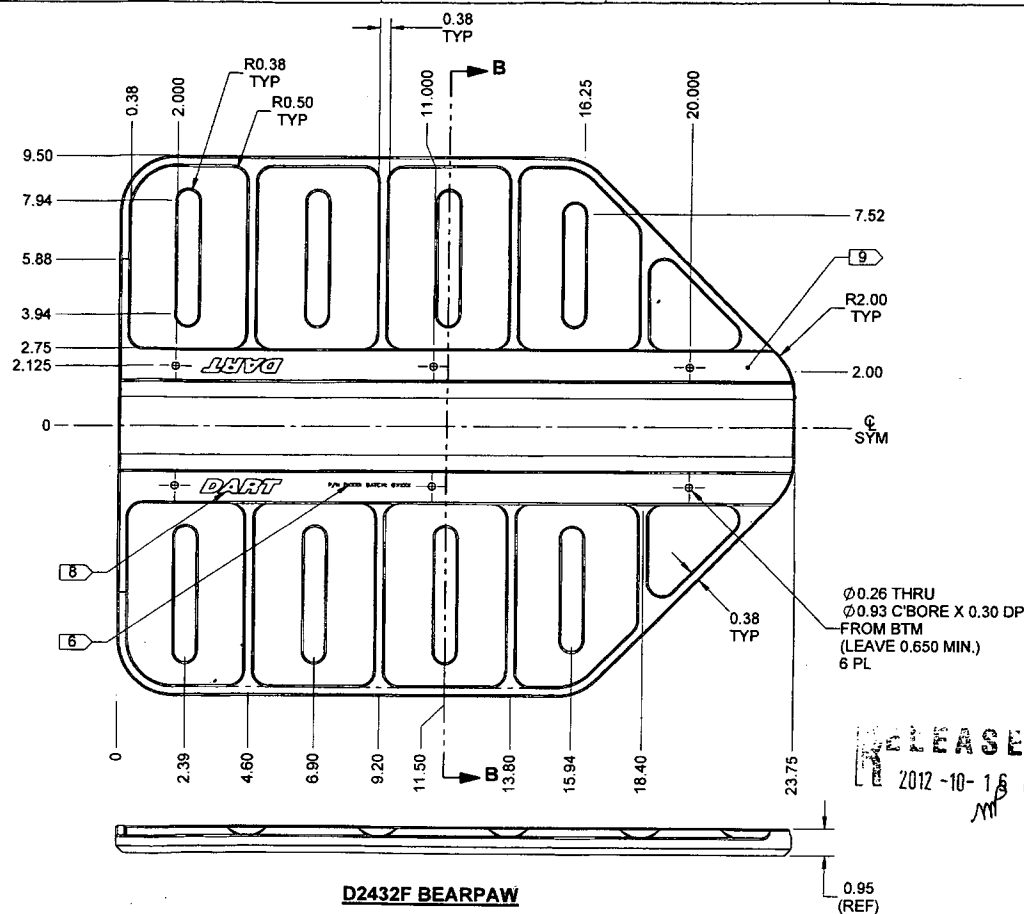
H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	91	<b>D2432</b>	SHEET 1 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	141	<b>BEARPAW</b>	NTS
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**DETAIL C**  
SCALE 2X



**SECTION B-B**



**D2432F BEARPAW**

**NOTES:**

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 5.87 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2434F-REVH.STP"

DESIGN	LE	<b>DART AEROSPACE LTD</b>	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	21	D2432	SHEET 2 OF 3
APPROVED	162	TITLE	SCALE
DE APPR.	16	BEARPAW	NTS
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2012-10-16

